

split

split
8/5 07/11/16

Date: Tuesday, 9/25/2007 10:11:43 AM
User: Kim Johnston

ⓐ

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34841 **B**
Estimate Number : 10913
P.O. Number : **N/A**
This Issue : 9/25/2007 S.O. No. : **N/A**
Prsht Rev. : **NC**
First Issue : **N/A** Type : LARGE FAB ASSY
Previous Run : 32891
Written By : **07.09.25**
Checked & Approved By : **07.09.25**
Comment : Est A 05.09.01 New issue KJ/JLM

Drawing Name : LUG ASSEMBLY
Part Number : D3405043
Drawing Number : D3405 REV A
Project Number : N/A
Drawing Revision : A
Material : **N/A**
Due Date : 10/10/2007

Qty: **29** Um: **18** Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 .125 Sheet



Comment: Qty.: 0.1617 sf(s)/Unit Total: 2.5872 sf(s)

5.1744

304/316 .125 Sheet

(M304S11GA)

Batch: **104934**

B 07-10-2

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3405

Dwg Rev: **A**

B 07-10-2

Prog Rev: **A**

2-Deburr if necessary

B 07-10-2

32

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-10-2

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En Holey

counter

32

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3405

07/11/07

32

B 07/11/07

29

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: *Alu/91 (x22)*

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

Handwritten: *B35810*

Handwritten: *M106P15*

Handwritten: *hf 08/01/14 (3x)*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

Handwritten: *hf 08/01/14 (3x)*

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: *hf 08/01/14 (3)*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: *hf 08/01/14 (3)*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: *hf 08-01-15 (3)*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: *hf 08/01/15 (3)*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51475*

Handwritten: *AS 08/01/15 (3)*

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Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/16

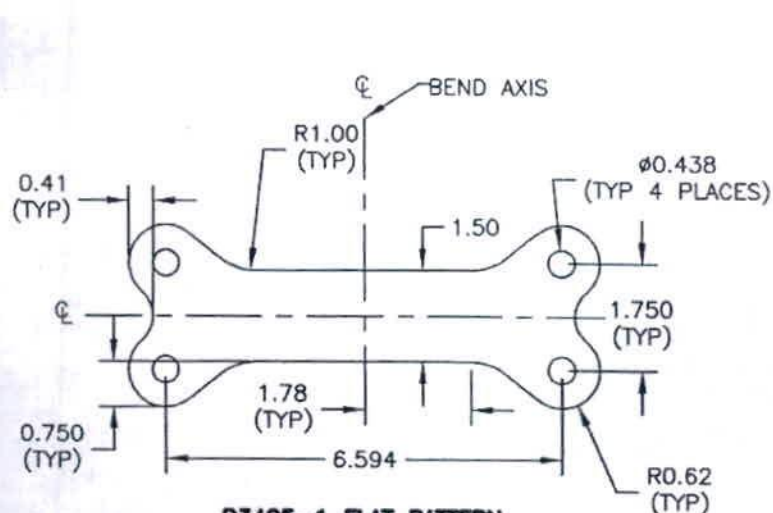
Job Completion



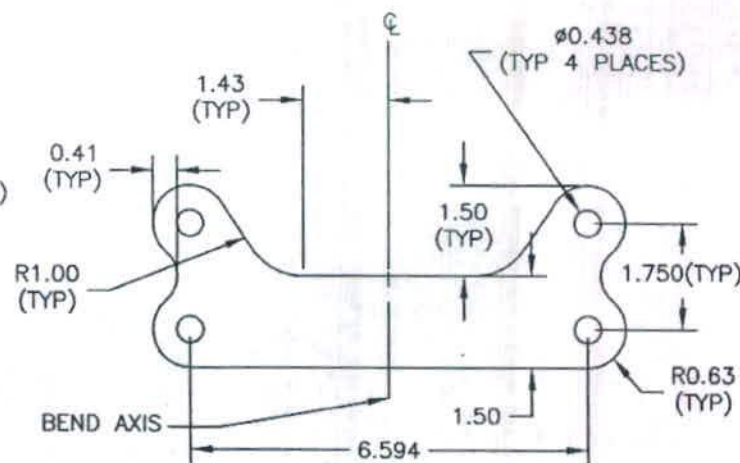
U 08-01-15

DART

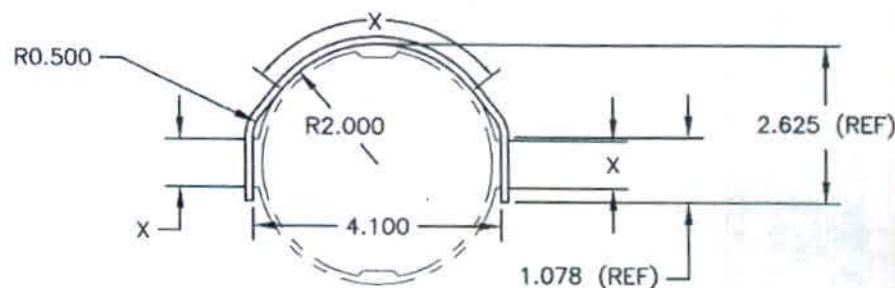
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.08	TITLE	D3405	REV. A
			GHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

SHOP COPY
RETURN TO
ENGINEERING
WORK ORDER
NO. 34841

DART AEROSPACE LTD		Work Order:	34841
Description: GHW Bracket		Part Number:	D3405-3
Inspection Dwg: D3405 Rev: A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype[illegible]

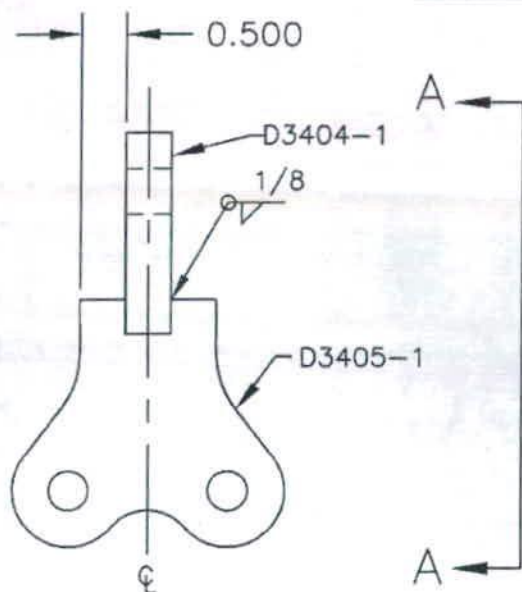
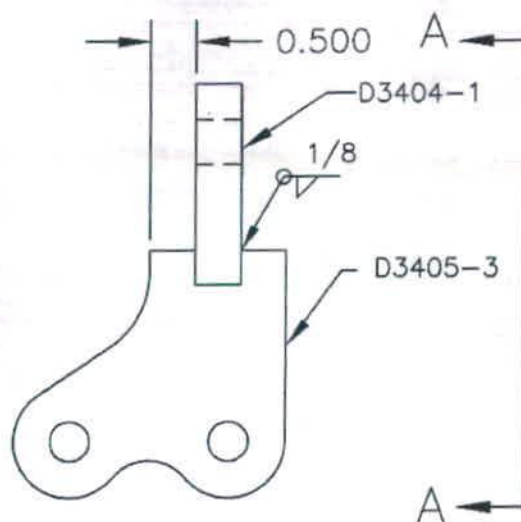
Measured by: <u>13</u>			Audited by: <u>En</u>			Prototype Approval: <u>N/A</u>	
Date: <u>07-10-2</u>			Date: <u>07/10/04</u>			Date: <u>N/A</u>	

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	<u>[Signature]</u>

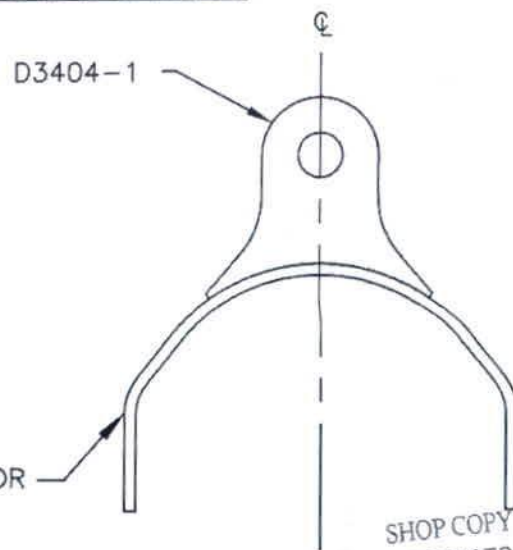
P/O D3405-043

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08	TITLE GHW LUG ASSEMBLY		SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09 *[Signature]*D3405-1 OR
D3405-3

SHOP COPY
VIEW A-A
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34841

D3405-041/-043 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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